



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A94-3000-00-3
Job Sheet 172375



3/30

Part No: RBE703A94-3000-00-3

Job Qty: 3 ea

Part Name: Narrow Frame Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE703A94-3000-00 Rev 0 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		2/28/18	0.00	0.00	Purchasing		At 18/03/18
110	Packaging	3 pcs		2/28/18	0.00	0.00	Packaging2		At 18/03/18
120	QC	3 pcs		2/28/18	0.00	0.00	QC6		30
130	Packaging	3 pcs		2/28/18	0.00	0.00	Packaging3		DAS 9-88
140	QC21-FG	3 Ea		2/28/18	0.00	0.00	QC21		21 MAR 29 2018

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 037054 MANUFACTURE RBE703A94-3000-00-3 AS
Descriptions: PER DWG ***Dart to supply -39 sticker*** -Certificate of conformity is required

0.2B

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE703A94-3000-00-3P	Narrow Frame Assembly	3 (1 ea)	100-Purchasing	5056125

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE703A94-3000-00-3P	3	0	0

Part Specifications

Specifications could not be found.

CONTAINER NO. 30000

Narrow Frame Assembly

PART NO: RBE703A94-3000-00-3

Serial No/Batch: S056128

Revision:

Operation: **Packaging**

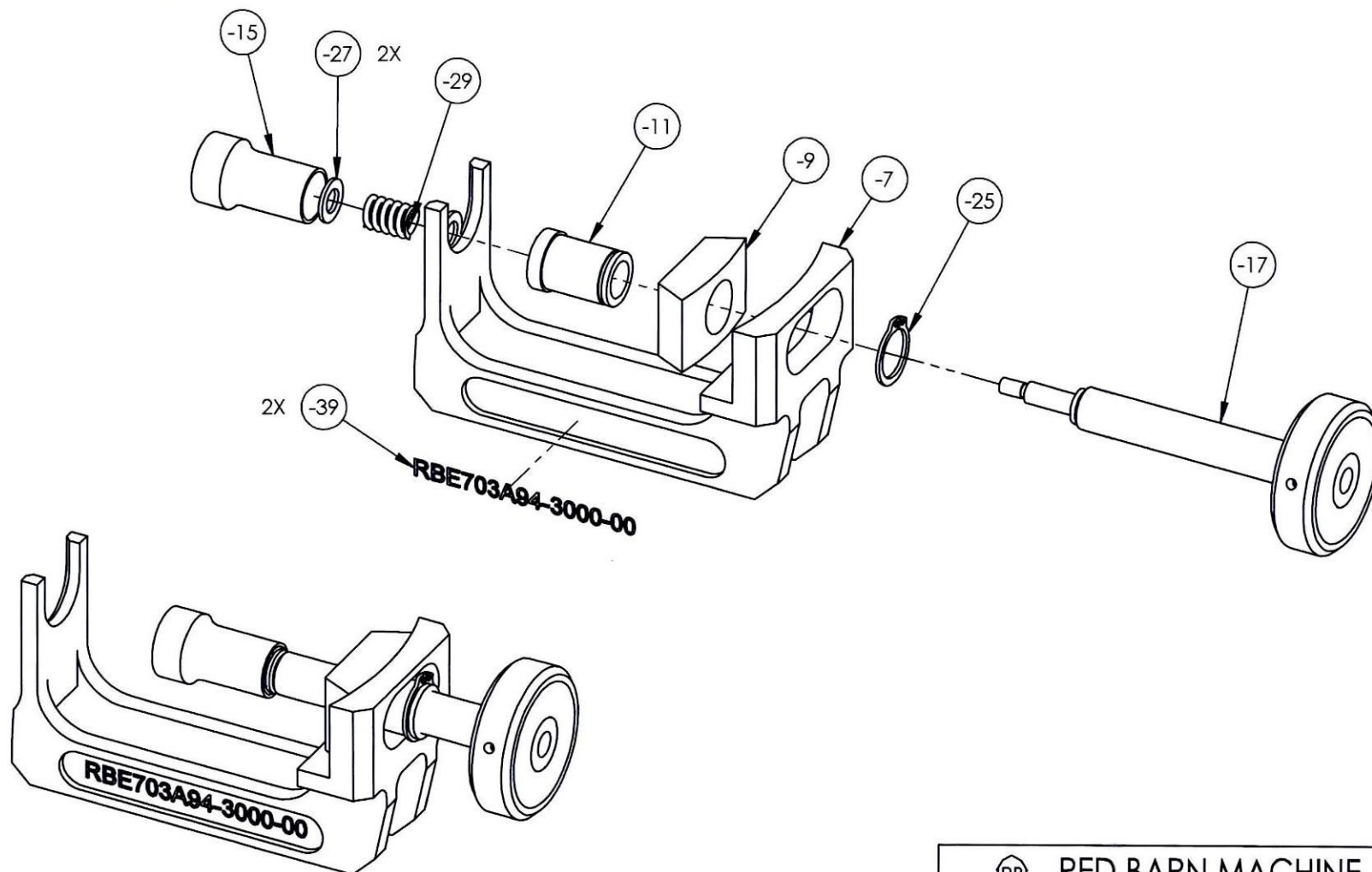
Change No:

Mfg Date: 03/28/18

Job No: 172375

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



(-3)
NARROW FRAME ASSY

RED BARN MACHINE	
TITLE TRH BEARING CLEARANCE MEASURING TOOL	
DWG NO. RBE703A94-3000-00-3	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:2	DATE 1/12/2012
SHEET 3 OF 17	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QS1042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>			Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>						Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
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Tel (613) 632-5200

PURCHASE ORDER **PO039084**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039084
PO Date: 2/21/18
Due Date: 4/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
MAR 06 2018

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RBSC7028-PP			Portable Bearing Cutter As Per Dwg RBSC7028-P Rev.6	Firmed	4/6/18	7 pcs	0 pcs	7 pcs	\$843.42/pcs	\$5,903.94
Line Item Note job# 172595											
2	RBE703A94-3000-00-1P			Wide Frame Assembly As Per Dwg RBE703A94-3000-00-1 Rev. 1	Firmed	3/20/18	3 Ea	0 Ea 3x	3 Ea	\$2,417.56/Ea	\$7,252.68
Line Item Note job# 172374											
3	RBE703A94-3000-00-3P			Narrow Frame Assembly As Per Dwg RBE703A94-3000-00-3	Firmed	3/20/18	3 Ea	0 Ea 3x	3 Ea	\$2,417.56/Ea	\$7,252.68
Line Item Note job# 172375											
4	RBW0805G00231-3GP			Adapter Assembly Helicopter Weighing As Per Dwg RBW0805G00231-3G-1	Firmed	4/30/18	9 Ea	0 Ea	9 Ea	\$564.82/Ea	\$5,083.38
Line Item Note job# 172567											
5	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$809.13/Ea	\$2,427.39
Line Item Note job# 172623											
6	RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$459.38/Ea	\$1,378.14
Line Item Note job# 172622											
7					Firmed	4/16/18	5 Ea	0 Ea	5 Ea	\$618.50/Ea	\$3,092.50

DAB
38
9-89



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 039084 Dated: 03/27/2018
Our Order / Job No: 23AWT Order Qty: 3 Assemblies
Part No: RBE703A94-3000-00-3 Part Name: Narrow Frame Assembly
Lot Size: N/A Ship Date: 03/23/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBE703A94-3000-00-3 Rev: No Rev
Material Size and Type: -7/6061 Alum.; -9/6061 Alum.; -11 Brass; -15/4140; -19/6061; -21/4140; -23 Brass
Material Specifications: STEEL-ASTM A108, ASTM A29; ALUMINUM-ASTM B221; BRASS-ASTM B16
Heat Treatment: N/A
Plating/Finish: 6061 CLEAR ANODIZE as per SPEC MILL-A8625F, TYPE II, CLASS I
CAD PLATE YELLOW QQ-P-416F, TYPE II, CLASS II

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 03/27/2018

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com